

Date: Wednesday, 9/12/2007 12:15:08 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	SADDLE KIT FOR D206-642-511		
Job Number	34625		Part Number	K642 511		
Estimate Number	12893		Drawing Number	N/A		
P.O. Number			Project Number	N/A		
This Issue	9/12/2007	S.O. No. :	Drawing Revision	N/A		
Prsht Rev.	NC		Material			
First Issue	/ /	Type : LANDING GEAR	Due Date	10/5/2007	Qty:	5 Um: Each
Previous Run	33975					
Written By	:					
Checked & Approved By	:					
Comment	Est Rev: A 07.06.05 new issue EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP K642-511 CHG003

07.10.02 J

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D206648013	GHW Kit
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

GHW Kit

Batch: B32401 -

4.0	D2652	Bushing
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick:

Qty Part Number

Description

16 D2652

Batch

B33993(64x)

333350 (16A) -

5.0	D2712	Set Screw
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Comment: Qty.: 10.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number

Description

10 D2712

Batch

B33218 -

07/09/2005

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: SADDLE KIT FOR D206-642-511

Job Number: 34625

Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description :

XH 12.0

D33963

Inventory



JP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number
2 D3396-3

Description

Batch

B32784 -

XH 13.0

D3407043

Tow Ring



JP



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number
1 D3407-043

Description

Batch

B34639 -

XH 14.0

D34561

washer



JP



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number
1 D3456-1

Description

Batch

B33276 -

XH 15.0

D34571

Inventory



JP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number
2 D3457-1

Description

Batch

B34640 -

XH 16.0

AN3C35A



JP



Comment: Qty.: 3.0000 Each(s)/Unit Total : 15.0000 Each(s)

Pick:

Qty Part Number
3 AN3C35A

Description

Batch

M105036 -

XH 17.0

AN3C36A



JP



Comment: Qty.: 9.0000 Each(s)/Unit Total : 45.0000 Each(s)

Pick:

Qty Part Number
9 AN3C36A

Description

Batch

M105688 -

JP 07/09/275

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: SADDLE KIT FOR D206-642-511

Job Number: 34625

Part Number: K642 511

Job Number:



Seq. #: Machine Or Operation:

Description :

18.0

AN3C41A



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN3C41A

Bolt

M105187 -

19.0

AN4C6A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 AN4C6A

Bolt

M104603 -

20.0

AN5C11A



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN5C11A

Bolt

M105634 -

21.0

AN5C12A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN5C12A

Bolt

M104936

M1057934x

22.0

AN5C13A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN5C13A

Bolt

M104999 -

23.0

AN5C15A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C15A

Bolt

M101291 -

EPP09/09/270

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT FOR D206-642-511

Job Number: 34625

Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN5C32A



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C32A

Bolt

M105156 -

25.0

AN5C34A



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C34A

Bolt

M105160 -

26.0

AN5C35A



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C35A

Bolt

M18918 -

27.0

AN960C10L

washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960C10L

Washer

M105143 -

28.0

AN960C416L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960C416L

Washer

M104936 -

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: SADDLE KIT FOR D206-642-511

Job Number: 34625

Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

AN960C516L

WASHER



JS.



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
8	AN960C516L	Washer	<i>M103344</i>

30.0

MS210433

Nut



JS.



Comment: Qty.: 20.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
20	MS21043-3	Nut	<i>M105730</i> <i>M105728-</i>

31.0

MS210434

Nut



JS.



Comment: Qty.: 13.0000 Each(s)/Unit Total : 65.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
13	MS21043-4	Nut	<i>M105430-</i>

32.0

MS210435

Nut



JS.



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	MS21043-5Nut		<i>M105054-</i>

33.0

NAS1515H3L

WASHER



JS.



Comment: Qty.: 24.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
24	NAS1515H3L	Washer	<i>M104517-</i>

34.0

NAS1515H4L

WASHER



JS.



Comment: Qty.: 24.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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JS. 10/19/2007

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: K642-511 PAR #: NA Fault Category: Prod/Packaging NCR: Yes No DQA: D Date: 07/10/04
 QA: N/C Closed: S Date: 07.10.04

NCR: 34625		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/01	H 33.0	Missing one washer Human error	/asical2	ADD missing washer	SP 07/10/01	S 07/10/01	081042	ES 07/10/01

NOTE: Date & initial all entries

Date: Wednesday, 9/12/2007 12:15:09 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT FOR D206-642-511

Job Number: 34625

Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description :

24 NAS1515H4L Washer *M105408*

~~H~~ 35.0

NAS1515H5

Washer

Comment: Qty.: 16.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick:

Qty Part Number

Description

16 NAS1515H5

Washer

M105728-

CJ.
M105135 (164)

~~H~~ 36.0

NAS1515H5L

WASHER

Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty Part Number

Description

8 NAS1515H5L

Washer

M104956 -

BB 07/09/27(5)

37.0 QC4

INSPECT 100% KITS FOR COMPLETENESS

Comment: INSPECT 100% KITS FOR COMPLETENESS

38.0 PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP K642-511 CHG003

Location: _____

BB 07/09/22(5)

07.10.02 JJ

39.0 QC21

FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 07-10-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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